

Work Order ID 72764

Friday, August 12, 2011 1:33:16 PM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-12 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M112860

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP/MO

11-9-14

11/09/14

BE 11/09/15

BE 11/09/15

DL 11/09/16

Dart Aerospace Ltd

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Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
116  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
120  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							



Sulorly

Sulorly

TH

11-09-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

DP

11-9-20

QC

Memo

0.00

Quality Control

150

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 *118392*

Sikaflex expire date: *12/04/05*

Start: *8/09/20* Time: *4:00*

Finish: ☐ Time: ☐

(Adhere for 12 hours)

BB 11/09/20

Dart Aerospace Ltd

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding



11-9-22

TW

11-9-22

SAD

11-09-26

①



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

DP

11-9-26



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R ☐ Aluminum Rod 112860

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

11/09/27

11-09-26

DP 11-9-27

1 φ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID • Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/11

AB →

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/11/11

(10)

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

XCP m-k 11/10/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D706-642541 PAR #: N/A Fault Category: Landing Gear BSKO NCR: (Yes) No DQA: / Date: 11-10-18

11-8161 Resolution: Re work Disposition: Re work QA: N/C Closed Date: 11/10/18

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/22	#190	Found at inspection that the Prod SADDLES do not align & cannot get into Bushing in the 21st hole. (Prod mat SADDLES hole). looks like	CP 11.09.27 051047	-> Drill out + remove D2649. -> Re weld in correct location new D2649 B 73857 qty 2 a/r. <u>M117087</u>	<u>DD</u> 11-10-3 BG 11/10/3	S 11/10/11	CP 11.09.27 051047	S 11/02/22
		X-bolt spacer Pullers as it was needed. R.C. Process	CP 11.09.27	-> Grind weld + counter Bore AS PER Dwg + Deburr.	<u>DD</u> 11-10-3	S 11/10/11	CP 11.09.27	S 11/02/22

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

0.00

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

250

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/R□□LPS-3□

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R□□Sikaflex-291 □

Sikaflex expire date:

12-5.

IXC m 11/10/12

1 BR 11-10-13.

1 BR 11-10-13.

Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

11-10-13 (1)

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ ☐ Sikaflex-291 ☐ 118393 ☐Sikaflex expire date: ☐ 12-5.

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N/A.

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ ☐ Sikaflex-291 ☐ 118393 ☐Sikaflex expire date: ☐ 12-5.

1 BR 11-10-13.

LPS. PROXYON. 114596.

Dart Aerospace Ltd

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Picklist Print

Friday, August 12, 2011 1:33:21 PM

Page 1

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Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 8/12/2011

Required Date: 8/24/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-190

Manufactured

No

110

Each

88.4000

1

1



Extrusion Round 3" 206

Location

Loc Qty

Loc Code

HALL

88.4

59874

29.4

69622

59

D3285-1

Manufactured

No

110

Each

99.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002

99

52511

52

52647

47

D3282-041

Manufactured

No

150

Each

2.0000

1



Float Web (206L/407)

Location

Loc Qty

Loc Code

LG

70050

2

69715

2

11-9-14
 BEU/09/15
 11/09/20

Dart Aerospace Ltd

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Required Date: 8/24/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

130.0000

12

12



Cross Bolt Spacer



11.09.26

Location

Loc Qty

Loc Code

LG	<u>B73390</u>	118
	68224	2
	71355	2
	72704	114
LG001		12
	65317	1
	68507	11

D3275-1

Manufactured No

190

Each

364.0000

12

12



Crossbolt Spacer



11.09.26

Location

Loc Qty

Loc Code

LG		161
	<u>72123</u>	161
LG002		203
	66930	106
	68946	72
	70688	25

CR3212-4-03

Purchased No

250

Each

1,174.000

2

2



Cherry Rivet



11-10-13

Location

Loc Qty

Loc Code

FP-B		2
	110139	2
ST311		1172
	114859	1172

Dart Aerospace Ltd

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Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/24/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041

Manufactured No

250 Each

56.0000

1

1



Nut Plate



BR 11-10-13.

Location

Loc Qty

Loc Code

ST053

56

33842

12

67605 ✓

44

CCR264SS3-3

Purchased

No

250

Each

471.0000

2

2



BR 11-10-13.

Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

469

117086

43

117849 ✓

426

ALS4-1032-130

Purchased

No

250

Each

2,276.000

78

78



BR 11-10-13.

Insert

Location

Loc Qty

Loc Code

ST281

378

117331

8

118386

370

ST282

1898

117717

54

118237

1588

118312

256

ALS7-1032-130.

117717
118966-

78.

Dart Aerospace Ltd

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Start Date: 8/12/2011


Required Date: 8/24/2011

Start Qty: 1.00


Required Qty: 1.00

D3536-15 Manufactured No 270 Each 16.0000 1 1

 Gasket


Location	Loc Qty	Loc Code
FP011	16	
66559	3	
71586 ✓	13	

D3536-23 Manufactured No 270 Each 25.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP011	25	
43406	1	
69902	12	
71579 ✓	12	

D3536-35 Manufactured No 270 Each 21.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP012 73313	21	
69755	7	
71587	14	

D3536-39 Manufactured No 270 Each 27.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP015	27	
66241	1	
69760 ✓	26	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 1:33:22 PM

Work Order ID: 72764

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/24/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No

270

Each

15.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

73006

15

68358

1

69931

14

D3535-35 Manufactured No

270

Each

22.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

73311

14

65926

1

67598

1

70815

12

ST

8

69756

8

D3535-39 Manufactured No

270

Each

13.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

72159

13

69759

13

D3535-23 Manufactured No

270

Each

25.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP021

25

68342

2

70818

11

71581

12

Friday, August 12, 2011 1:33:22 PM

Shop Packet Print

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 1:33:22 PM

Work Order ID: 72764

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/24/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270 Each

23.0000

1 1



Wearpad



BL 11-10-13

Location

Loc Qty

Loc Code

FP

17

70481 ✓

17

FP017

6

35697

1

72686

5

D3537-1 Manufactured No

270 Each

27.0000

9 9



Wearpad



BL 11-10-13

Location

Loc Qty

Loc Code

FP

20

71574

20

FP017

7

69817

5

70686

2

AN960C10L NAS1149C0332 / Purchased No

270 Each

0.0000

80 80



washer



80 BL 11-10-13

AN960C416 NAS1149C0463 / Purchased No

270 Each

0.0000

1 1



washer



1 BL 11-10-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 1:33:22 PM

Page 7

Work Order ID: 72764

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/24/2011

Start Qty: 1.00

Required Qty: 1.00

~~X~~ D3672-1
Phenolic Washer

Manufactured No

270 Each

1,412.000

2 2



BL 11-10-13.

Location

Loc Qty

Loc Code

ST074

1410

64177

414

66821 ✓

496

72229

500

ST077

2

52505

2

AN3C4A

Purchased No

270 Each

1,361.000

80 80



BL 11-10-13.

BOLT

Location

Loc Qty

Loc Code

ST350

1361

117313

2

117688

36

117795

1

117872

22

118012

260

118112

40

118451 ✓

1000

AN4C5A

Purchased No

270 Each

493.0000

1 1



BL 11-10-13.

BOLT

Location

Loc Qty

Loc Code

FP-B

103

112243 ✓

103

ST345

390

112243

390

Friday, August 12, 2011 1:33:22 PM

Shop Packet Print

Page 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 1:33:22 PM

Work Order ID: 72764



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 8/12/2011

Required Date: 8/24/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

101.0000

1

1



Aft Cap



BL 11-10-13.

Location

Loc Qty

Loc Code

FP004

54

68280 ✓

54

1

FP006

5

62678

5

FP-4

38

70945

1

71070

37

fp5

4

71038

4

D3413-1

Manufactured No

270

Each

28.0000

1

1



Ring



BL 11-10-13.

Location

Loc Qty

Loc Code

ST420

27

66387

1

70773

25

71041

1

ST473

1

66945

1

73248.

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12764
11-08-12

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3274	REV. 0 SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

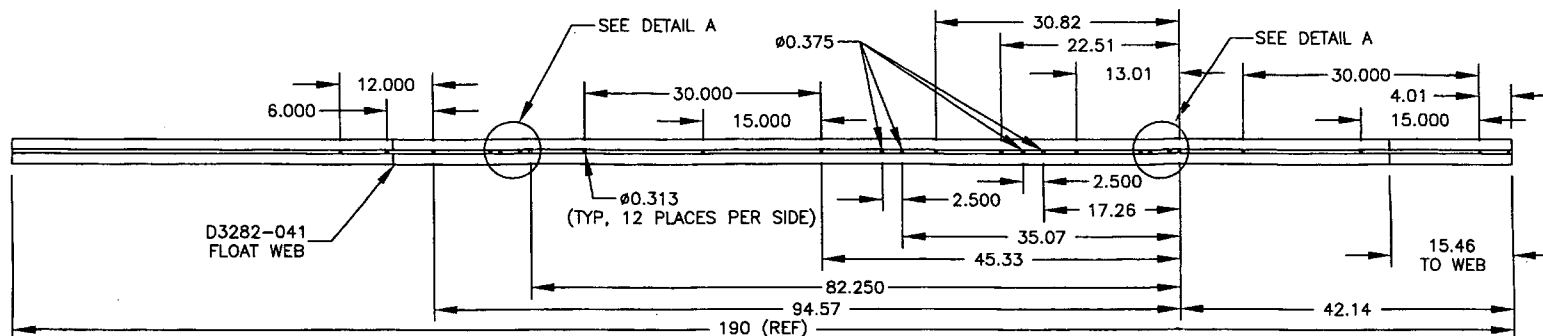
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

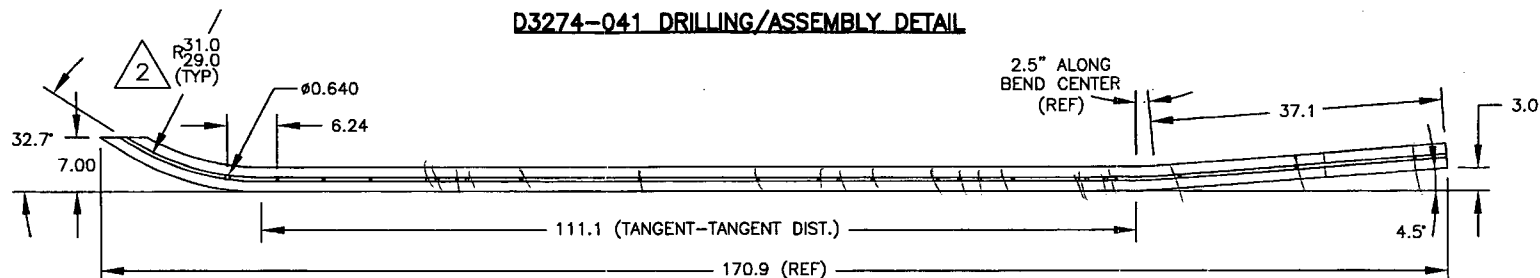
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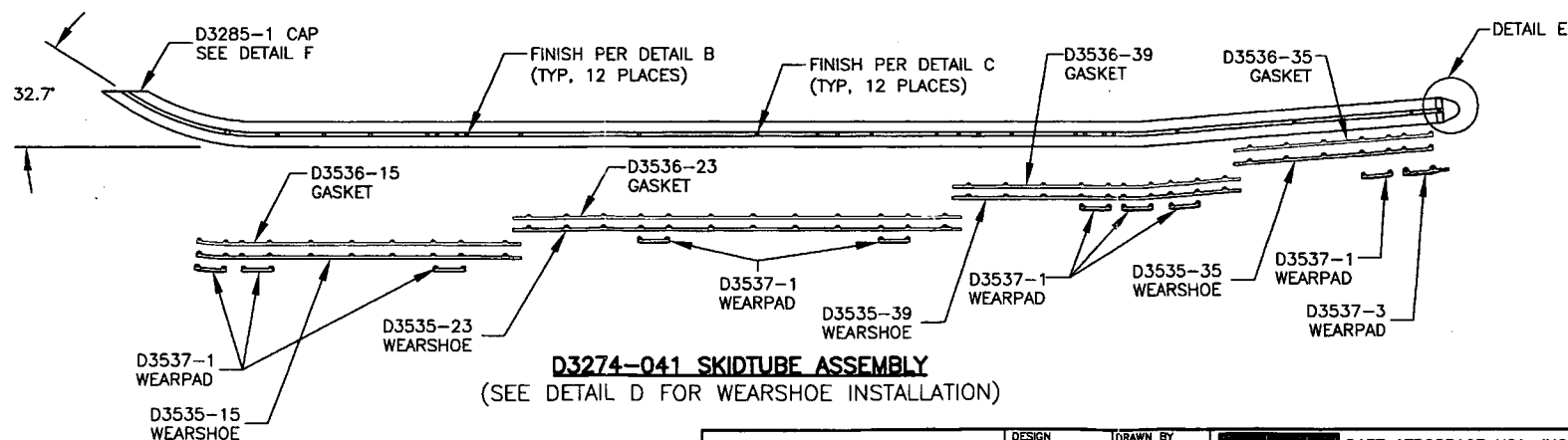
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

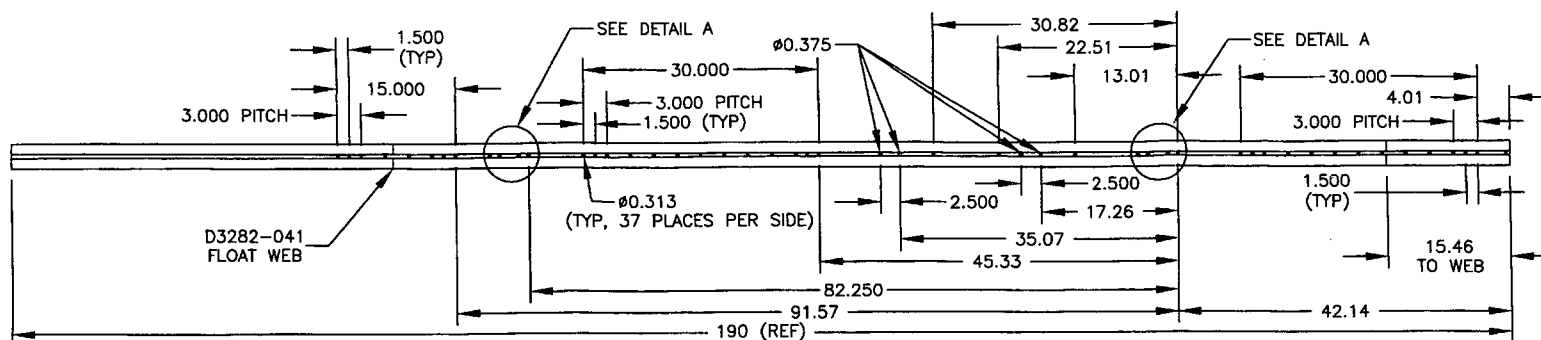
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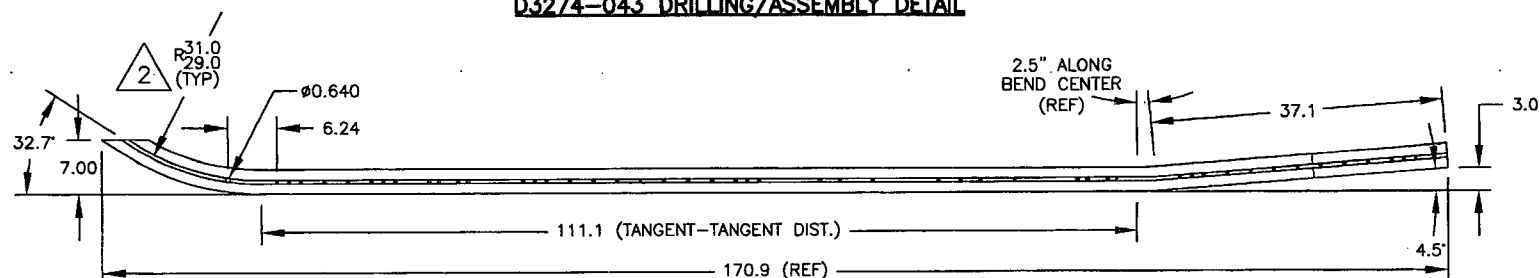
DESIGN	CP	DRAWN BY	PH	DART	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	DRAWING NO.	D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D	SHEET 2 OF 4
				SCALE	1:15

72264

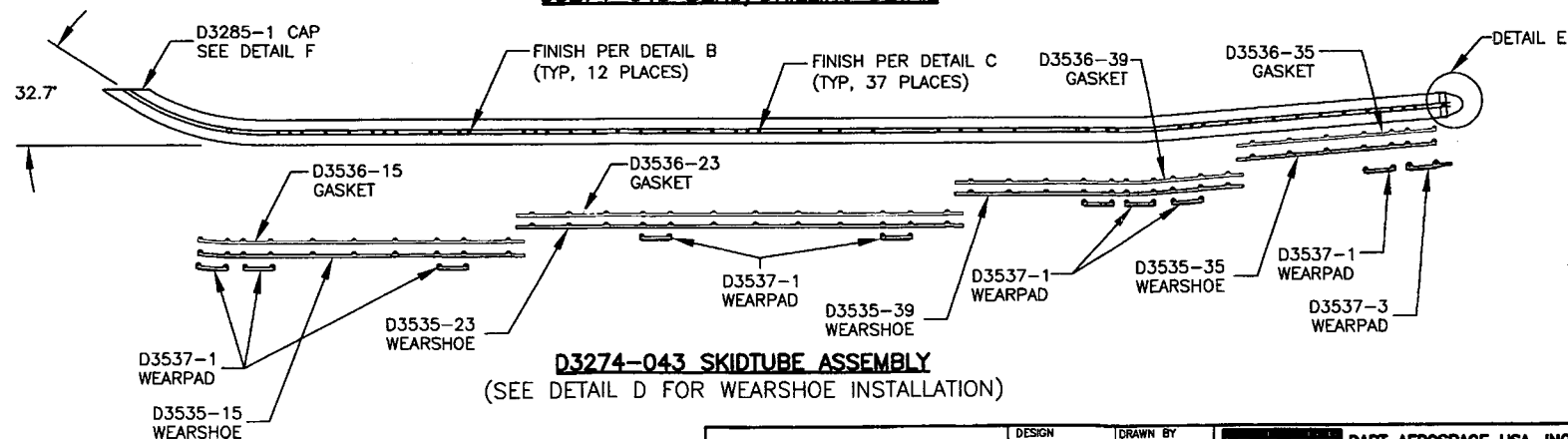
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL

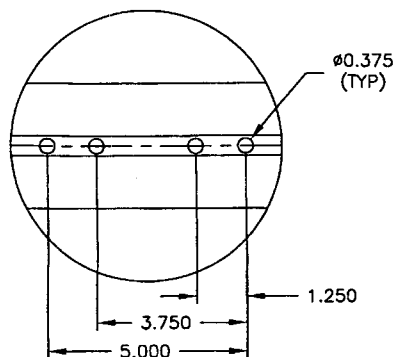
D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

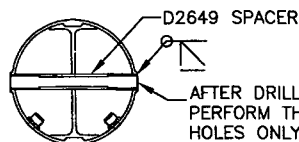
07.02.12

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		CP	PH	PORT HADLOCK, WA	
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		#	#	D3274	SHEET 3 OF 4
		DATE		TITLE	SCALE
		06.12.19		SKIDTUBE ASSEMBLY	1:15

DETAIL A: DRILL DETAIL

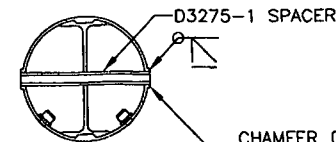


DETAIL B FOR 0.375 HOLES ONLY



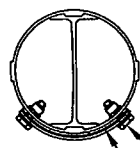
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

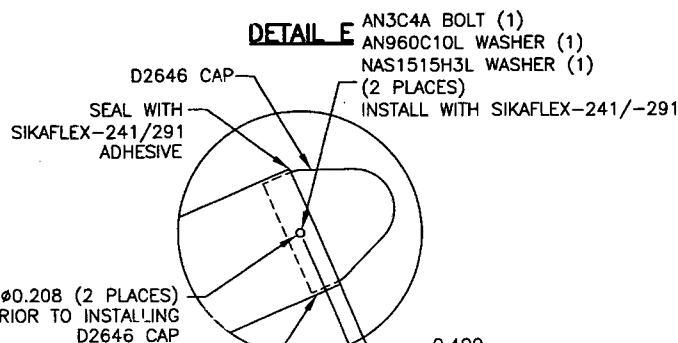
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

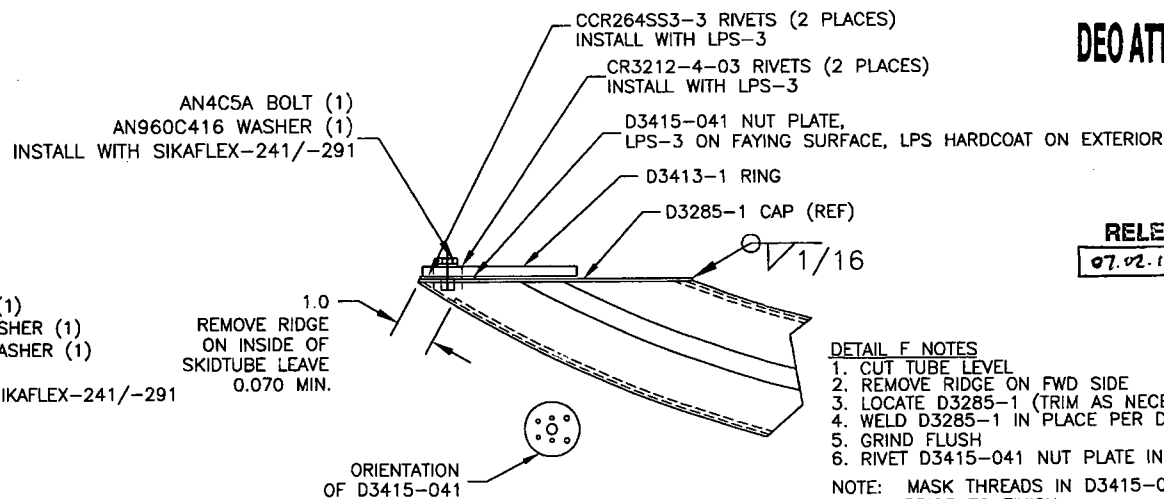
DETAIL E



0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED

07.02.12

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DATE 06.12.19		CHECKED #	APPROVED #	TITLE SKIDTUBE ASSEMBLY	SCALE 1:3

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>2</i>	MFG. APPR. <i>MA</i>	APPROVED <i>MAP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

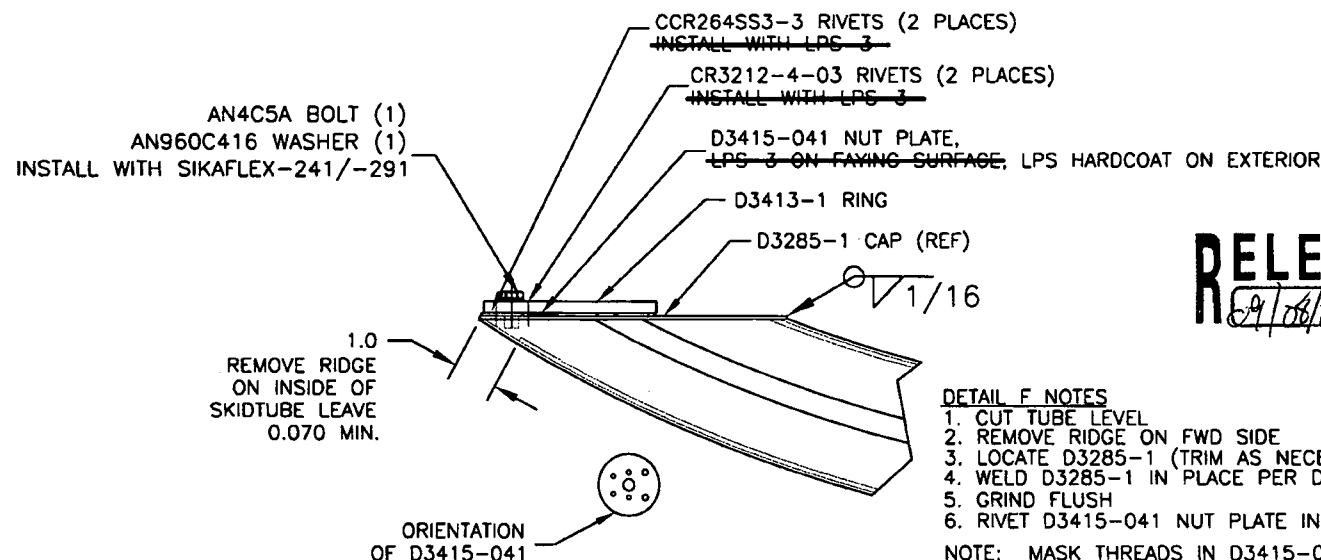
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

72269

DETAIL F: END FINISHING DETAIL

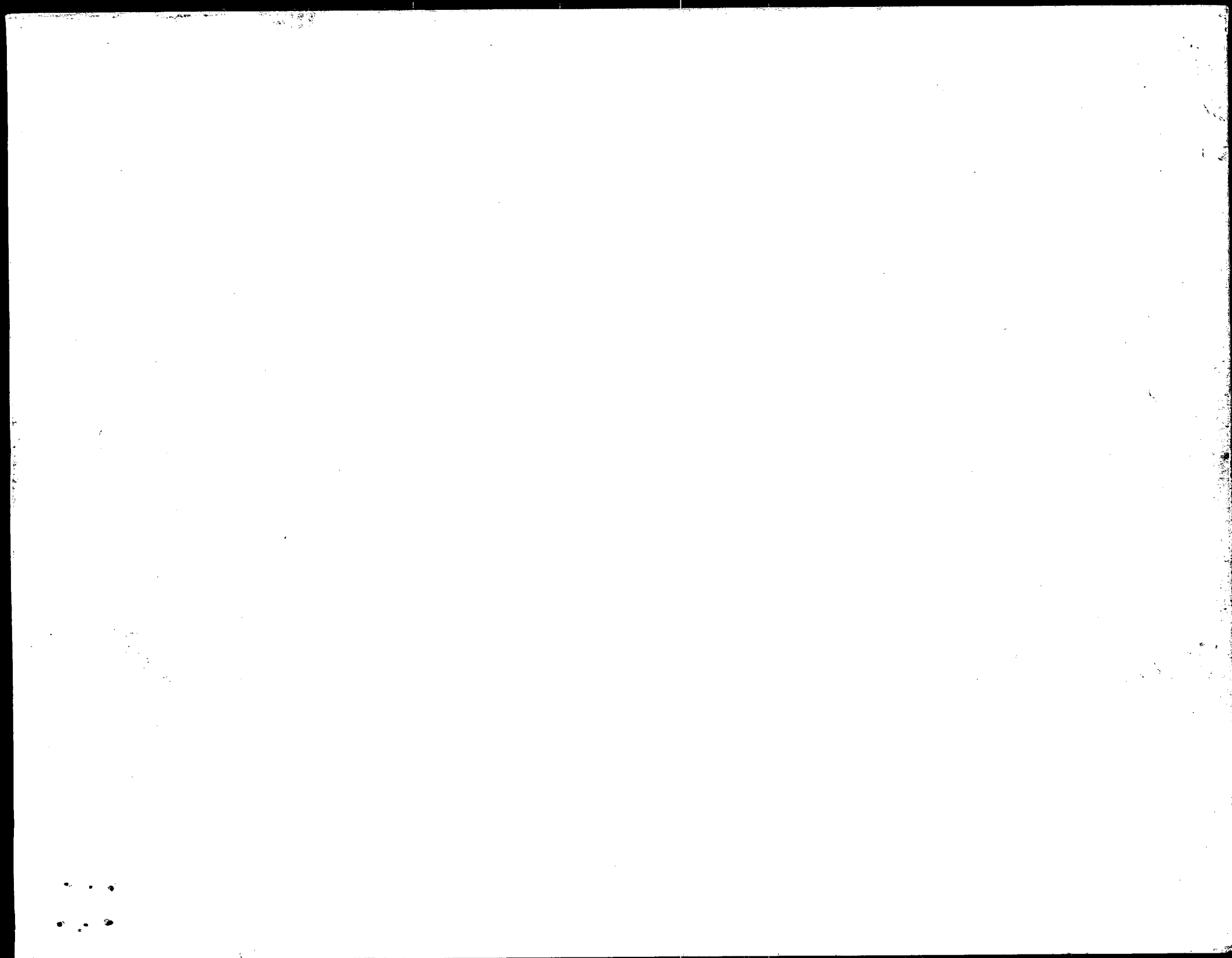


RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH



NO. 269

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 738930
Part number: D206 642 151
Description: 206 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier Lat. Quinn Date of Test Coupon 11.10.07
Welder Barclay Elliott Date of Test Coupon 11.10.07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld